

Date: Thursday, 04/09/2008 1:23:23 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FITTING
Job Number	: 41829		
Estimate Number	: 11396		
P.O. Number	:	Part Number	: D32993
This Issue	: 04/09/2008 S.O. No. :	Drawing Number	: D3299 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 40257	Material	:
Written By	:	Due Date	: 30/09/2008
Checked & Approved By	: <u>JUL 08.9.04</u>	Qty:	20 / 12 Um: Each
Comment	: Est: A 04.10.04 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6H1000	6061-T6 HexBar 1.00
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Comment: Qty.: 0.1925 f(s)/Unit Total : 2.3096 f(s)  
 6061-T6 1" HexBar  
 Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.00" Hex  
 (M6061T6H1.000)  
 Identify as D3299-3  
 Batch: M105238 mme 08/09/15

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: Machine as per Folio FA452 and Dwg D3299  
 Deburr

mme 08/09/15 SA 08/09/16 (21)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mme 08/09/15 SA 08/09/16 (21)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 08-09-16 (21)

5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
-----	-----------------	-----------------------



Comment: Sub-Contracting OUTSIDE SERVICES  
 Issue P/O: 2174  
 Anodize as per Dwg D3299  
 Possible Supplier: TNM Paint  
 Material release note is required

Co 08/09/16 (21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 04/09/2008 1:23:23 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 41829

Part Number: D32993

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

*LC 8/9/25 (21)*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Sodor 8/25 (22) counter*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 82

*8/9/25*

*(21)*

*SL*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/09/30 (23)*

Job Completion



*MF 08-09-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 41829
Description: Fitting		Part Number: D3299-3
Inspection Dwg: D3299	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.068	/			
Ø0.302	+0.005/-0.000	Ø.304	/			
0.550	+/-0.010	.557	/			
0.63	+/-0.030	.642	/			
2.08	+/-0.030	2.100	/			
0.900		.898	✓			
53°		53°	✓			
0.476	-0.005/+0.000	.473	✓			
MOW for 9/16"-18	Min = 0.5653 Max = 0.573	.570	✓			
0.200	+/-0.030	.199	✓			
0.450	+/-0.010	.446	✓			
0.10	+/-0.030	.096	✓			
Length of Engagement for 1/4 NPT 0.227	+/-0.010	.225	/			

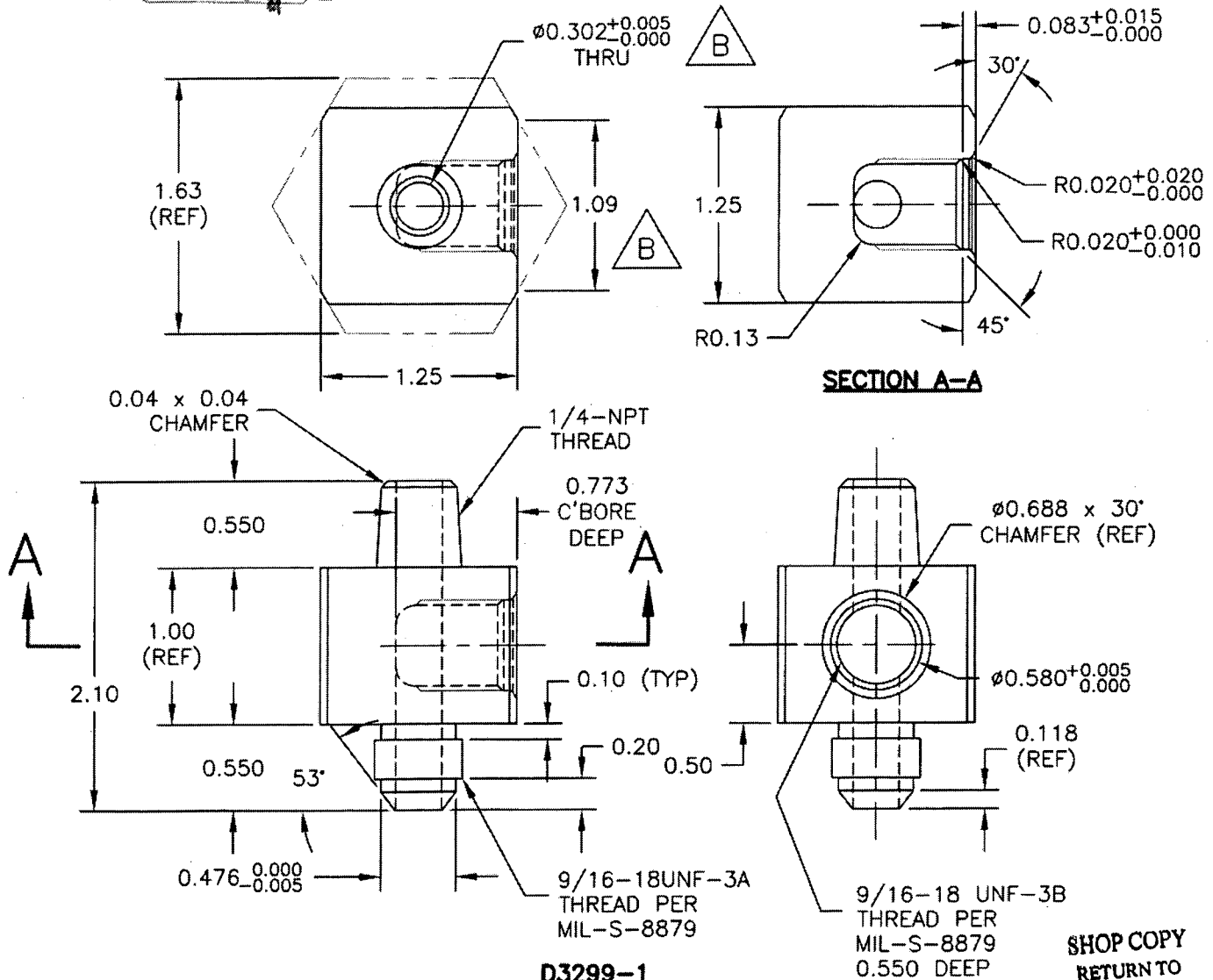
Measured by: SD	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/09/16	Date: 08.09.16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.17	New Issue	KJ/JLM	
B	05.05.25	-0.005/+0.000 added to 0.476	KJ/JLM	
C	08.07.23	Dwg Rev updated	KJ/DD	[Signature]



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28	TITLE FITTING		SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; $\phi 0.302$ WAS $\phi 0.297$	

RELEASED  
05-04-28 #



D3299-1

**D3299-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.63)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER  
NO. 41829

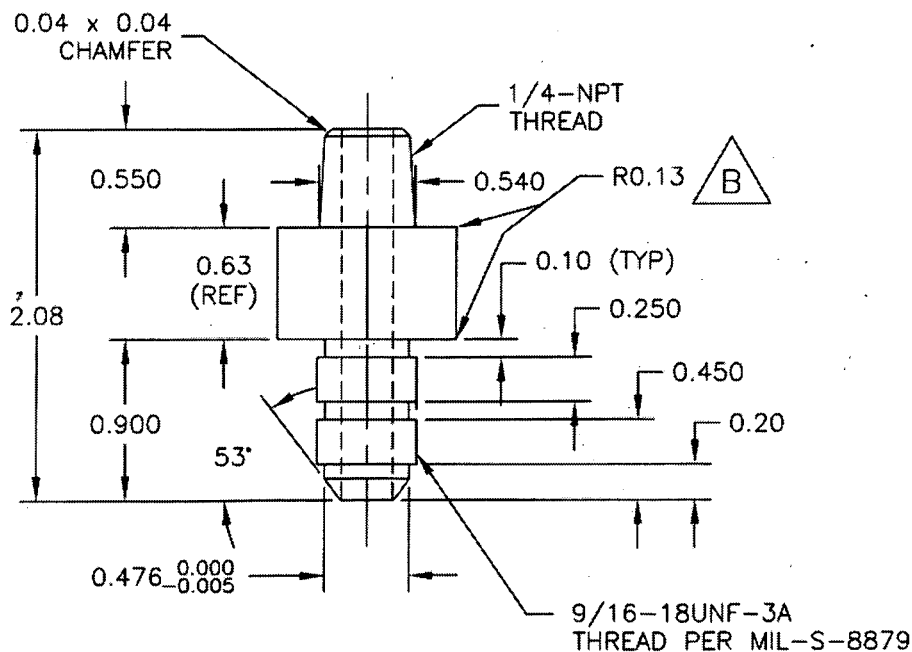
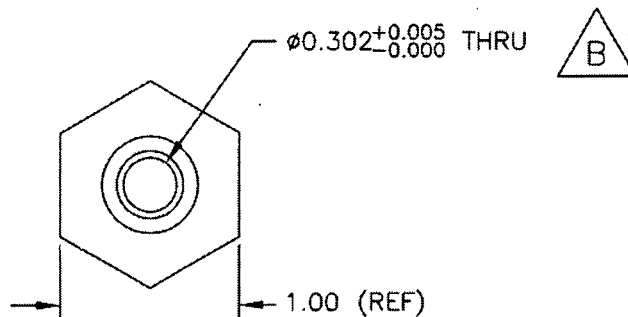
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3299	REV. B SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1

RELEASED  
05.04.28



**D3299-3**

**D3299-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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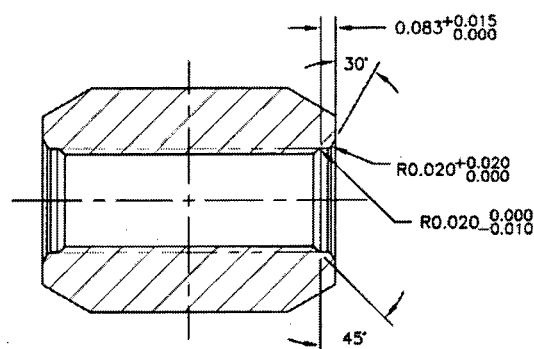
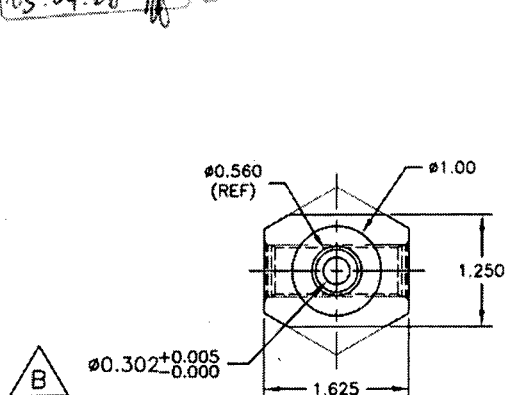
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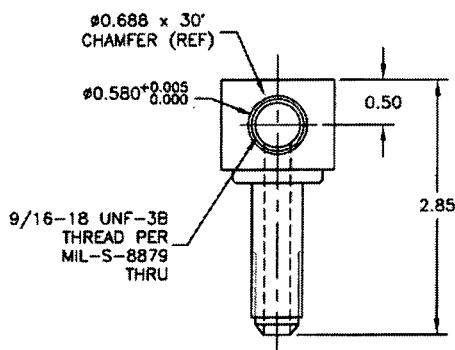
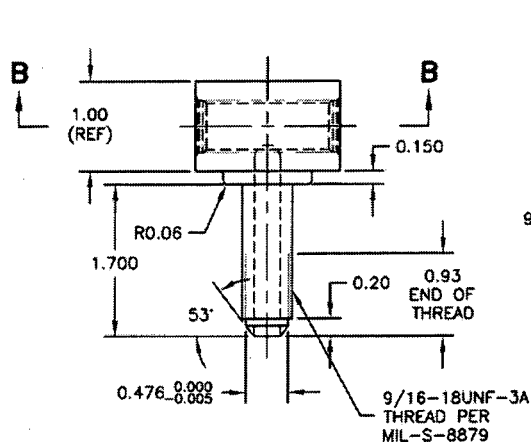


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CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:2

RELEASED  
05.04.28



SECTION B-B  
SCALE 1:1



D3299-5

**D3299-5 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TMM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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**TNM****ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

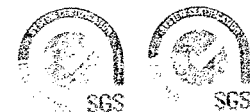
Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified  
approuvé NADCAP approved

68350

23-Sep-2008

CLIENT / CUSTOMER:

**DART AEROSPACE LTD.**1270 ABERDEEN STREET  
HAWKESBURY , ONTARIO  
K6A 1K7**CERTIFICATE OF COMPLIANCE**  
**CERTIFICAT DE CONFORMITE****NO. DE COMMANDE: 7174**  
**PURCHASE ORDER/****Nadcap**  
Chemical Process  
Nondestructive Testing

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PART PROCESS & TREATMENT
1	110	110	D103-858-B	B41592	MATL: AL BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	21	21	D3299-3	B41829	MATL: AL BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.  
Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient  
Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air  
ambiant.

Signature/Signed: \_\_\_\_\_

Directeur de la Qualité / Q.A. Manager